

Ecomass® 706BI76

Acrylonitrile Butadiene Styrene

Ecomass Technologies

Message:

Ecomass® 706BI76 is an Acrylonitrile Butadiene Styrene (ABS) material filled with filler. It is available in North America for injection molding. Primary attribute of Ecomass® 706BI76: Flame Rated.

General Information			
Filler / Reinforcement	Filler		
Features	Medium Density		
	Platable		
Forms	Pellets		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Density	2.49	g/cm ³	ISO 1183
Molding Shrinkage (4.00 mm)	0.30 to 0.50	%	Internal Method
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress (Yield)	20.0	MPa	ISO 527-2
Tensile Strain (Break)	3.0 to 5.0	%	ISO 527-2
Flexural Modulus	5470	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Notched Izod Impact Strength ¹ (23°C)	64	kJ/m ²	ISO 180/A
Thermal	Nominal Value	Unit	Test Method
Heat Deflection Temperature			
0.45 MPa, Unannealed	94.0	°C	ISO 75-2/B
1.8 MPa, Unannealed	84.0	°C	ISO 75-2/A
Vicat Softening Temperature	97.0	°C	ISO 306
Flammability	Nominal Value	Test Method	
Flame Rating (1.50 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature - Desiccant Dryer	82.2	°C	
Drying Time - Desiccant Dryer	2.0	hr	
Drying Time, Maximum	6.0	hr	
Processing (Melt) Temp	204 to 246	°C	
Mold Temperature	65.6 to 82.2	°C	
Injection Pressure	68.9 to 103	MPa	
Injection Rate	Moderate-Fast		
Back Pressure	0.103 to 0.172	MPa	
Screw Speed	100 to 250	rpm	

Clamp Tonnage	3.4 to 5.5	kN/cm ²
Cushion	6.35 to 12.7	mm
Screw L/D Ratio	20.0:1.0	
Screw Compression Ratio	2.5:1.0	
NOTE		
1.	3.2 mm	

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Recommended distributors for this material

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